

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000810**Date Inspected:** 06-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77 & 89 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance (QA) Inspector observed ZPMC Magnetic Particle Testing (MT) Technician Cai Xinxin performing testing on the root welds of the 89 Meter Mock-Up, MUSB-MA21 A/J between web plates A, C & D. These were weld number 55, 56, 57, 58 and 61 which the root welds were tested. These welds were found acceptable by the ZPMC MT Technician. Mr. Cai also started performing MT on the tack welds MUSB-MA24 between plates mp531-1 to p873; mp531-2 to p873 and MA24-1 to p873. Mr. Cai however quit performing testing when he noted that there was a missing tack weld which he pointed out to the floor supervisor. Testing was halted until the remaining tack weld can be completed.

This QA Inspector witnessed the ultrasonic testing (UT) of 89 Meter Mock-Up Skin plate Sub-Assembly Face 'C' complete joint penetration (CJP) weld MUSB-MA23-25. Testing was performed by ZPMC UT Technicians Li Li Ming and E Shui Qin using zero, 45 and 70 degree transducers. The weld was found acceptable by both Mr. Li and Miss E.

The QA Inspector performed 10% verification UT on the 77 Meter Mock-Up Skin E CJP T-joint welds. Welds were between the mp5 plates and the MA1 plate. Welds tested were 3, 4 and 5. For details please see ultrasonic testing report 6027 dated November 3, 2007.

Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
